

Work Order ID 86323

Wednesday, June 27, 2012 10:53:43 AM

86323

Page 1

Item ID: D4422-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 6/27/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/27/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *12-06-27* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4422

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Shear as per dwg D4422

1

0

FF
12-06-27

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

(1)

8
12/06/27

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

PJ0
12/06/27

115-

W/O: 86323

Pen C & G

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-06-27	115	- must be absolute - Add to routing.	RS H	12627		h	

Part No: D4422-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4422-1

Revision ID:

Item Name: Shim

Start Date: 6/27/2012

Required Date: 6/27/2012

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Start Qty: 1.00

1

Cust Item ID:

Req'd Qty: 1.00

1

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center ID

130

130

QC

Quality Control

Operation
Description

QC21 - Final Inspection - Work Order Release

Memo


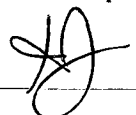
Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp12/6/28 
12.06.27

Picklist Print

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Work Order ID: 86323

Parent Item: D4422-1

Parent Item Name: Shim

Start Date: 6/27/2012

Required Date: 6/27/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.06.30 new issue ec verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.125

6061-T6 .125 Sheet

Purchased

No

sf

33.4745

0.0169474

① 88-12-06-27

Location

Loc Qty

Loc Code

MAT021

33.4745

121473

33.4745

0.0169474

8 7 6 5 4 3 2 1

D

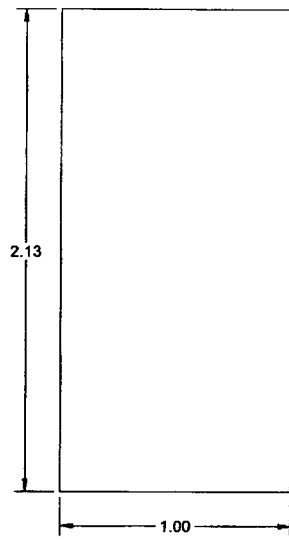
C

B

D

C

B



D4422-X SHIM



P/N	"T" THICKNESS
D4422-1	0.125
D4422-3	0.063

NOTES:

1) MATERIAL:

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
OR
6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T8B

D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1
7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

#56323

RELEASED
2011-07-06

A		NEW ISSUE		MB		11.06.22	
REV.		DESCRIPTION				BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				REV. A	SHEET 1 OF 1
DRAWN							
CHECKED		DRAWING NO. D4422				SCALE	
MFG. APPR.		TITLE SHIM				NTS	
APPROVED		DATE 11.06.22					
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8 7 6 5 4 3 2 1